

CLAIMS

1. An In-Mould Labelling process comprising:
 - 5 clamping a label within a mould void of an injection moulding tool; and
injecting material into the mould void while the label is clamped.
2. A method as claimed in claim 1, wherein clamping occurs automatically as
a result of a mould forming process.
- 10 3. A method as claimed in claim 2, wherein the mould forming process
comprises:
relative movement between a mould cavity, a label location core and a mould
core until the mould cavity and the mould core abut to define a portion of the
15 mould void and until the label location core and the mould core abut to define
a further portion of the mould void and clamp the fabric label
4. A method as claimed in claim 3, wherein the label location core and the
mould core co-operate to define a shut-off volume into which injected material
20 cannot enter
5. A method as claimed in claim 4, wherein the shut-off volume receives a
lanyard or eyelet attached to the label.
- 25 6. A method as claimed in claim 3, 4 or 5, wherein the label location core
moves through an opening in the mould cavity towards the mould core and
wherein the mould core comprises clamping members that extend toward the
label location core for abutting the label location core and clamping the fabric
label.
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7. A method as claimed in claim 6, wherein the clamping members are resiliently biased for full extension toward the label location core.

5 8. A method as claimed in any one of claims 3 to 7, wherein the label location core has a projection or projections towards the mould core for clamping the fabric label.

9. A method as claimed in claim 8, wherein the projection is a continuous projection

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10. A method as claimed in any proceeding claim, wherein clamping involves a plurality of resiliently biased clamping members that extend at least partially into the mould void while clamping the label.

15 11. A method as claimed in claim 10, wherein a clamping member is positioned at, at least, each corner of the label.

12. A method as claimed in claim 10 or 11, wherein the label is a laminate comprising a substrate layer and a fabric layer and the clamping members
20 abut the substrate layer.

13. A method as claimed in claim 12, wherein the clamping member comprises gripping projections located where the clamping member abuts the laminate label

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14. A method as claimed in claim 12 or 13, wherein the laminate label is pre-formed to a desired shape.

15. An In-Mould Labelling apparatus comprising:
30 a multi-portion body defining a mould void and at least one conduit for injecting material into the mould void; and

a plurality of clamping members extending at least partially into the mould void for clamping a label within the mould void.

16. An apparatus as claimed in claim 15, wherein the multi-portion body
5 comprises a mould cavity, a label location core and a mould core arranged for relative movement and having a first injection configuration in which they co-operate to define the mould void and clamp the label within the mould void and a second non-injection configuration for releasing a moulded article.
- 10 17. An apparatus as claimed in claim 16, wherein the label location core and the mould core are arranged to co-operate in the first injection configuration and define a shut-off volume into which injected material cannot enter.
- 15 18. An apparatus as claimed in claim 17, wherein the shut-off volume is sized to house a lanyard or eyelet attached to the label.
19. An apparatus as claimed in any one of claims 15 to 18, wherein the mould cavity and the mould core abut, in the first injection configuration, to define a portion of the mould void, and the label location core and the mould
20 core abut, in the first injection configuration, to define a further portion of the mould void and clamp the label
20. An apparatus as claimed in claim 19, wherein a portion of the mould cavity facing the mould core has cut-outs that provide for a particular shape of
25 mould void.
21. An apparatus as claimed in any one of claims 15 to 20, wherein the mould cavity has an opening, the clamping members extend from the mould core, and the label location core, in the injection configuration, extends through the
30 opening towards the mould core and abuts the clamping members.

22. An apparatus as claimed in claim 21, further comprising a bias between the label location core and mould cavity resisting movement of the locating portion through the opening.

5 23. An apparatus as claimed in claim 22, further comprising a mechanism for moving the label location core towards the mould core.

24. An apparatus as claimed in any one of claims 15 to 23, wherein the label location core has a projection or projections towards the mould core for
10 clamping the label.

25. An apparatus as claimed in claim 24, wherein the projection is a continuous projection.

15 26. An apparatus as claimed in any one of claims 15 to 25, wherein the clamping members are resiliently biased.

27. An apparatus as claimed in any one of claims 15 to 26, wherein the label has a plurality of corners and one of the clamping members is positioned at
20 each corner of the label.

28. An apparatus as claimed in any one of claims 15 to 27, wherein each clamping member comprises gripping projections located where the clamping member abuts the label .

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29. A moulded article manufactured in accordance with the method as claimed in any one of claims 1 to 14.

30. A moulded article having an exterior surface, the article comprising:
30 an injection moulded body having a plurality of slots extending through the body; and

a label that extends over at least a portion of the exterior surface of the article, wherein portions of the label are received within the slots

5 31. A moulded article as claimed in claim 30, wherein the portion of the exterior surface of the article over which the label extends comprises a plurality of corners and a slot is positioned, at least , at each of the plurality of corners.

10 32. A moulded article as claimed in claim 30 or 31, wherein the portions of the label received within the slots has gripping artefacts.

33. A moulded article as claimed in any one of claims 30 to 32, wherein the label is a laminate comprising a substrate layer and a fabric layer.

15 34. A moulded article as claimed in any one of claims 30 to 33, wherein the label has edges and the injection moulded body comprises a groove for concealing the edges of the label and terminating the portion of the exterior surface over which the label extends

20 35. A moulded article as claimed in claim 34, wherein the groove is continuous and intermittently defines the slots.

25 36. A moulded article as claimed in any one of claims 30 to 35, wherein the Injection moulded body comprises wall strengthening portions adjacent the slots.

37. A moulded article as claimed in any one of claims 30 to 36, wherein the injection moulded body has a substantially constant thickness.

30 38. A moulded article having an exterior surface, the article comprising: an injection moulded body comprising a groove; and

a label comprising a plurality of edges, wherein the label extends over at least a portion of the exterior surface of the article and the edges of the label are received within the groove.

5 **39.** An article comprising:

a first injection moulded part having a plurality of first slots extending through the first injection moulded part;

a second injection moulded part having a plurality of second slots extending through the second injection moulded part; and

10 a label that extends over at least a portion of the first injection moulded part and a portion of the second injection moulded part, wherein portions of the label are received within the first slots and within the second slots.

15 **40.** A mobile cellular telephone housing comprising as a part thereof a moulded article as claimed in any one of claims 30 to 38.

41. An In-Mould Labelling apparatus comprising:

a multi-portion body defining a first mould void and at least one conduit for injecting material into the first mould void, a second mould void and at least

20 one conduit for injecting material into the second mould void ; and

means for placing a label so that it extends from the first mould void to the second mould void.

25 **42.** An apparatus as claimed in claim 41, wherein the multi-portion body further comprises a shut-off volume into which material is not injected, positioned between the first mould void and second mould void, wherein the placed label extends across the shut-off volume.

43. An In-Mould Labelling process comprising:

30 placing a label between a first mould void and a second, separate mould void; and

injecting material into the first and second mould voids.

44. A laminate label for use in an injection moulding process comprising a substrate layer and a fabric layer.

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45. A laminate label as claimed in claim 44, wherein the fabric layer comprises Alacantara.

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46. A laminate label as claimed in claim 44 or 45, wherein the substrate layer comprises polycarbonate.

47. A laminate label as claimed in claim 44, 45 or 46, wherein the substrate layer is less than 1 millimetre thick.

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48. A laminate label as claimed in any one of claims 44 to 47, having an indent where it terminates.

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49. A laminate as claimed in claim 48, wherein the laminate is three-dimensional having sidewalls, wherein at least a portion of one side wall terminates with the indent.

50. An injection moulded article comprising a laminate as claimed in claim 48 or 49, wherein the indent is hidden in use.

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51. A method of forming a pre-form label for use in an in mould labelling process comprising:

moulding a laminate comprising a substrate layer and a fabric layer to indent a continuous portion of the laminate; and
cutting the laminate so that it terminates at the continuous indented portion.

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52. A method as claimed in claim 51, wherein the step of moulding the laminate moulds the laminate into a three-dimensional shape having side walls wherein at least a portion of one side wall terminates with the indent.

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